

Date: Thursday, 1/17/2008 3:31:33 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	DOUBLER		
Job Number	36844					
Estimate Number	10227					
P.O. Number	:		Part Number	D2151		
This Issue	1/17/2008	S.O. No. :	Drawing Number	D2151 REV B		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	B		
Previous Run	34467		Material	:		
Written By	:		Due Date	1/31/2008	Qty:	100
Checked & Approved By	:		Um:	Each		
Comment	Est C 00.10.23 Re-format (mpp 2101) EC Est Rev:D 06-04-28 Manufactured on Water Jet JLM Est Rev:E 06-11-24 As per Rev B JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		 <b>Comment:</b> Qty.: 0.0368 sf(s)/Unit Total : 3.6750 sf(s) <b>Material:</b> 2024-T3 (QQ-A-250/4) 0.040" thick <b>(M2024T3S.040)</b> <b>Batch:</b> <u>106072</u> <b>RB</b> 8-1-22
2.0	WATER JET	FLOW WATER JET
		 <b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D2151 Dwg Rev: <u>B</u> <b>RB</b> 8-1-22 Prog Rev: <u>B</u>
		 <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>RB</u> 8-1-22
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <b>Comment:</b> SECOND CHECK <u>RB</u> 8-1-22
4.0	QC8	SECOND CHECK
		 <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 <u>RB</u> 08/01/24 <b>109</b>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/01/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: DOUBLER
Job Number: 36844		Part Number: D2151
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		HS 08-01-28 X109
7.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		M 10637H 109
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		M 109 08/01/29
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: S+17		P 08/01/30 109
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		20810131 109
Job Completion		 U 08/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36844
Description: Packer	Part Number:	D2151
Inspection Dwg: D2151	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	UB
Date:	8-1-22

Audited by:	<u>J. S. Collier</u>
Date:	20/01/25

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

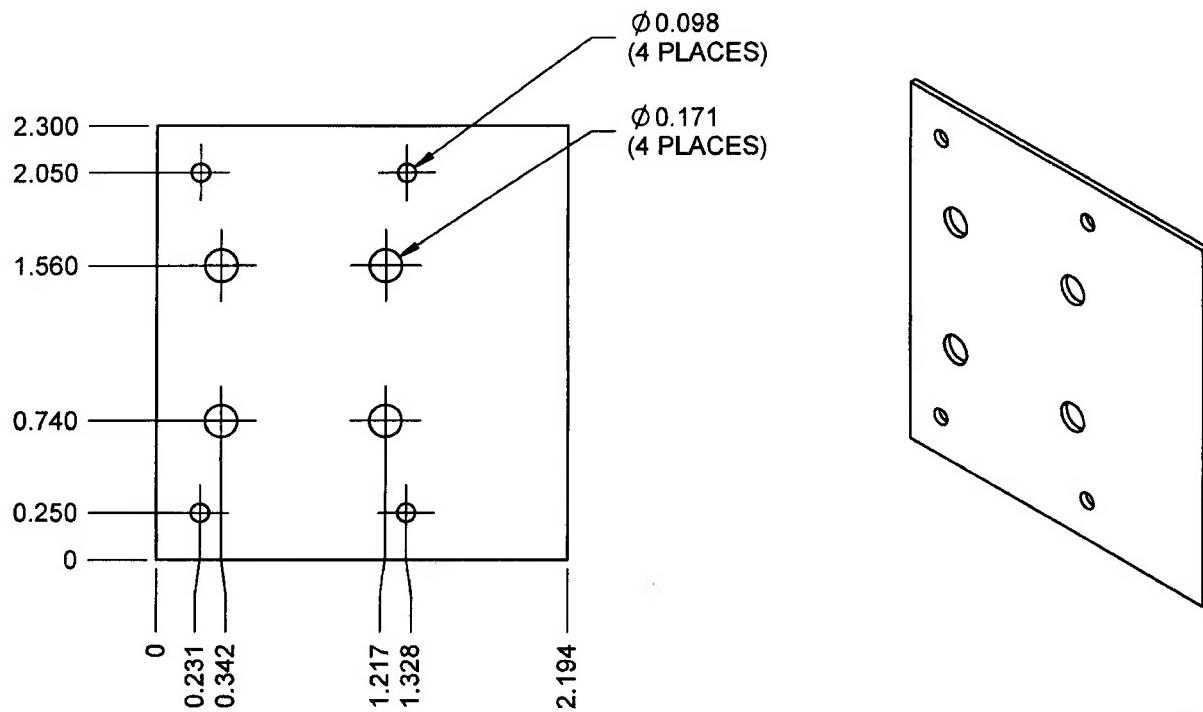
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	EE

**DART**

DESIGN BW	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>MM</i>	DRAWING NO. <b>D2151</b>
DATE 06.10.13	TITLE <b>PACKER</b>	REV. B SHEET 1 OF 1 SCALE 1:1

REV	DATE	DESCRIPTION
A	95.05.01	NEW ISSUE
B	06.10.13	UPDATE DRAWING

RELEASED

06.11.20 *MM***D2151 PACKER**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
BREAK ORDER  
NO. *36844*

**NOTES:**

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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